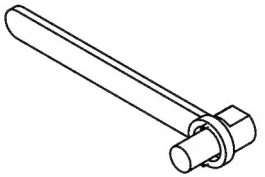
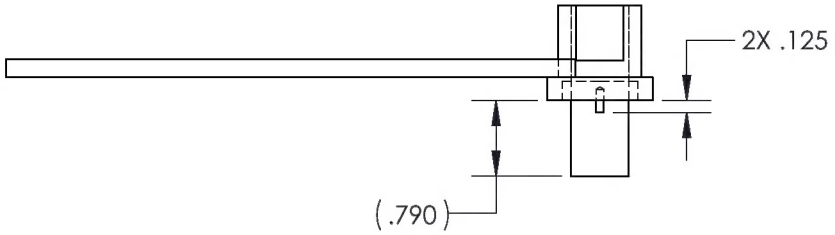
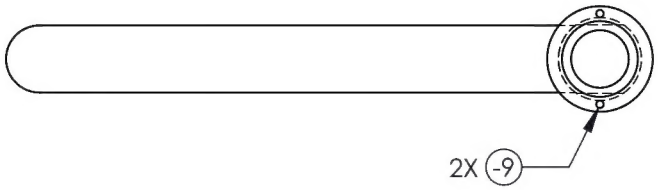
REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0214	ADDED NOTE 1 SHEET 1. **-1** CH'D WELD CALLOUT WAS FILLET WELD TOP & BOTTOM IS FILLET WELD TOP AND BEVEL WELD BOTTOM, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE 1 SC2, CH'D DWG. TO SHEET METAL TOLERANCE. **-3** & **-5** CH'D MATERIAL WAS 4140 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34. **-3** CH'D DIM WAS Ø.5995/.5988 IS Ø.5995/.5988 (P.F. -9) WAS 2X Ø.07875/.07850 ↧.115 IS 2X Ø.0786/.0782 ↧.12 (P.F. -9), WAS ⌴ Ø.790 ↧.200 IS ⌴ Ø.79 ↧.20. **-5** DELETED DIM .09 X 45°, 5.93, CH'D DIM WAS (.1875) IS .19, WAS 6.18 IS (6.18), ADDED DIM 6.18, 5.75. **-7** CH'D DIM WAS Ø.6004/.6000 IS Ø.6004/.6000 (P.F. -3).	11/7/2016	RJC	SM







NOTE:
1. REF. AGUSTA T/N 109-3501-03-17.
2. USED IN KIT RBW109-3501-03-1.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-3		BASE	4140/4142		3
	1		-5		HANDLE	4140/4142		4
			-7	1	PIN	6061		5
		B/O	-9	2	DOWEL PIN	STEEL	Ø2mm X 6mm (MCMASTER-CARR #91595A020)	1
	ASSY -1							

DART AEROSPACE

TITLE: WRENCH ASSY

DWG NO. RBW109-3501-03-17 REV 2

MAT'L
HEAT TREAT
FINISH
SPEC

DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK

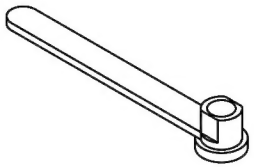
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125√
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

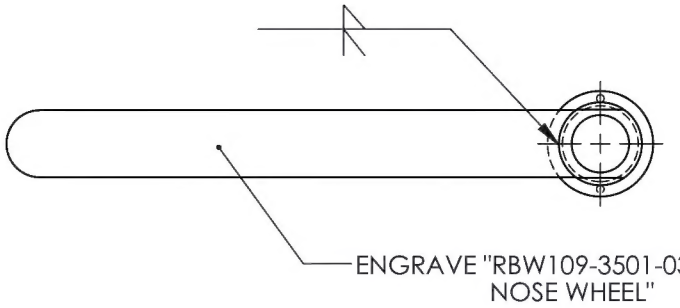
USED ON MODEL: AW109

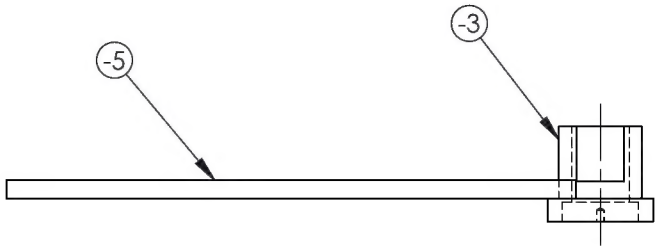
SCALE 1:2 DATE 4/5/2011 SHEET 1 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0214	**-1** CH'D WELD CALLOUT WAS FILLET WELD TOP & BOTTOM IS FILLET WELD TOP AND BEVEL WELD BOTTOM, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE 1 SC2, CH'D DWG. TO SHEET METAL TOLERANCE.	11/7/2016	RJC	SM







-1

WELDMENT

DART AEROSPACE

TITLE: WRENCH ASSY

DWG NO. RBW109-3501-03-17-1 REV. 2

MAT'L	
HEAT TREAT	
FINISH	ZINC PLATE
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK
SCALE	1:2
DATE	4/5/2011

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

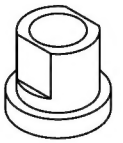
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

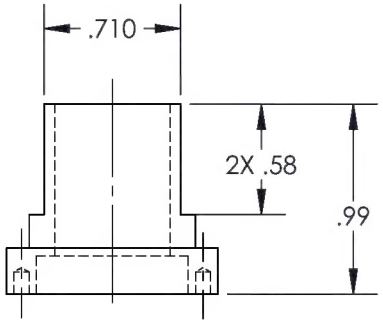
USED ON MODEL: AW109

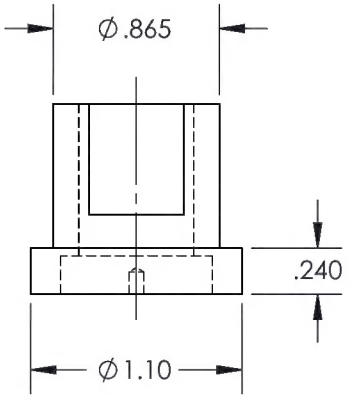
SHEET 2 OF 5

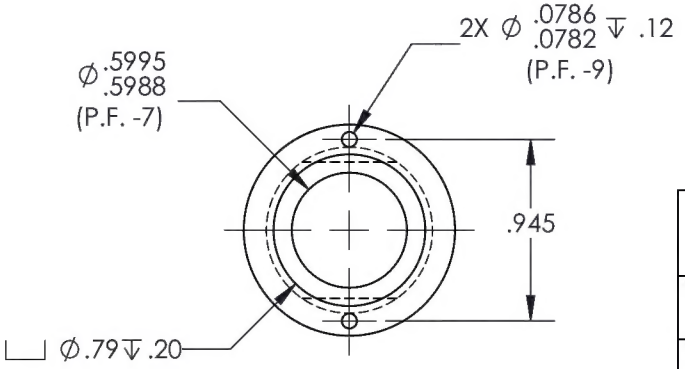
REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0214	**-3** CH'D DIM WAS Ø.5995/.5988 IS Ø.5995/.5988 (P.F. -9) WAS 2X Ø.07875/.07850 ↧.115 IS 2X Ø.0786/.0782 ↧.12 (P.F. -9), WAS ⌴ Ø.790 ↧.200 IS ⌴ Ø.79 ↧.20, CH'D MATERIAL WAS 4140 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34.	11/7/2016	RJC	SM









-3

BASE

DART AEROSPACE

TITLE: WRENCH ASSY

DWG NO. RBW109-3501-03-17-3 REV 2

MAT'L	4140/4142
HEAT TREAT	RC 28-34
FINISH	SEE -1 WELDMENT
SPEC	
DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125√

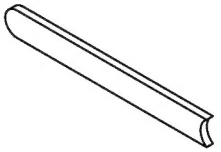
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

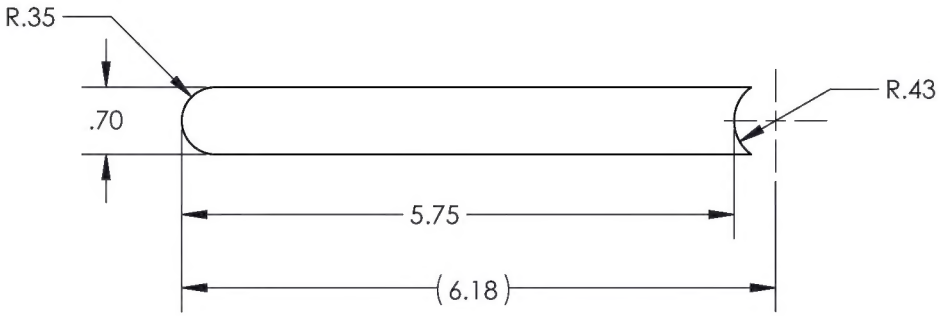
USED ON MODEL: AW109

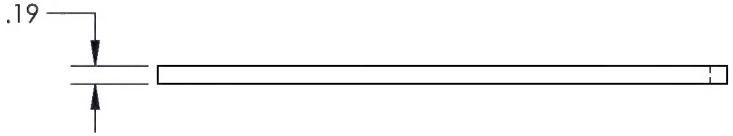
SCALE 1:1 DATE 4/5/2011 SHEET 3 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0214	**-5** DELETED DIM .09 X 45°, 5.93, CH'D DIM WAS (.1875) IS .19, WAS 6.18 IS (6.18), ADDED DIM 6.18, 5.75, CH'D MATERIAL WAS 4140 Q&T IS 4140/4142 ADDED HEAT TREAT RC 28-34.	11/7/2016	RJC	SM







(-5)

HANDLE

DART AEROSPACE

TITLE: WRENCH ASSY

DWG NO. RBW109-3501-03-17-5 REV 2

MAT'L	4140/4142
HEAT TREAT	RC 28-34
FINISH	SEE -1 WELDMENT
SPEC	
DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

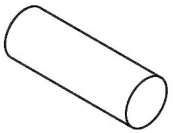
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

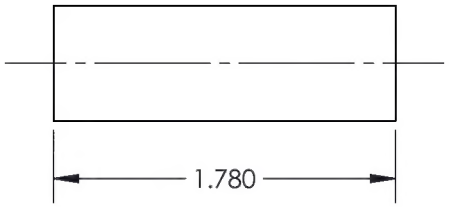
USED ON MODEL: AW109

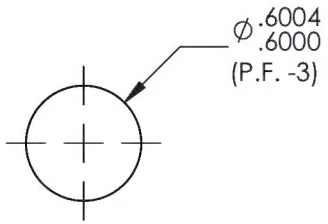
SCALE 1:2 DATE 4/5/2011 SHEET 4 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0214	**-7** CH'D DIM WAS Ø.6004/.6000 IS Ø.6004/.6000 (P.F. -3).	11/7/2016	RJC	SM







-7

PIN

DART AEROSPACE

TITLE: WRENCH ASSY

DWG NO. RBW109-3501-03-17-7 REV 2

MAT'L	6061
HEAT TREAT	
FINISH	CLEAR ANODIZE
SPEC	MIL-A-8625F, TYPE II, CLASS I
DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL: AW109

SCALE 1:1 DATE 4/5/2011 SHEET 5 OF 5